












Date: Tuesday, 11/22/2005 9:50:31 AM  
 User: Linda Lacelle

## Process Sheet

Cust	: QU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG ASSEMBLY
Job	: 2895C	Part Number	: D3175041
Estimate Number	: 10816	Drawing Number	: D3175 REV. A
P.O. Number	: N/A	Project Number	: N/A
This Date	: 11/22/2005 S.O. No. : N/A	Drawing Revision	: A
Prsh	: NC	Material	: N/A
First	: N/A Type : SMALL /MED FAB	Due Date	: 12/15/2005
Prev Run	: 22409C	Qty:	1 Um: Each
Written By	: <u>SEE COMMENT BELOW</u>		
Check & Approved By	: <u>SEE COMMENT BELOW</u>		
Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		
Additional Product			
Job Number: 			
Step:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"	
			
Comment: Qty.: 0.2012 f(s)/Unit Total: 0.8047 f(s) Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) M6061T6B1.500x02.500 Batch: <u>M16142</u> <u>M8 05/11/27 4</u>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") <u>M8 05/11/27 4</u>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA293 and Dwg D3175 Deburr and Tumble Identify as D3175-1 <u>M8 05/11/27 4</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>M8 05/11/27 4</u>			
5.0	QC3	SECOND CHECK	
			
Comment: SECOND CHECK <u>En 05/11/28 4</u>			

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Drawing Name: MOUNTING LUG ASSEMBLY

Number: 24895C

Part Number: D3175041

Job Number:



Step #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 105/12/03 4

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

205-12-05 4

8.0

D31751

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bracket

(Note: (2) D3175-1 are required per D3175-041 assembly)

Pick:

Qty	Part Number	Description	Batch
2	D3175-1	Bracket	24895 C

2

9.0

D31753

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
4	D3175-3	Spacer	B 24890 A

2

10.0

AN37A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3-7A	Bolt	M 5280

2

11.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10L	Washer	M 18235

2

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Number: 24895C

Part Number: D3175041

Job Number:



Step #:

Machine Or Operation:

Description:

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M17652

2

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3175

DL 05/12/15 2

14.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

205-12-16

2

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

g m 06-02-13

16.0

QCS

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m/ 06 02 14

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57130

06/2/15 (2)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

500 06/02/16 (2)

06/02/16 (2)

Job Completion





[illegible]

Measured by:	
Date:	

Date:

Audited by:	
Date:	

Date:

Prototype Approval:	
Date:	

Date:	
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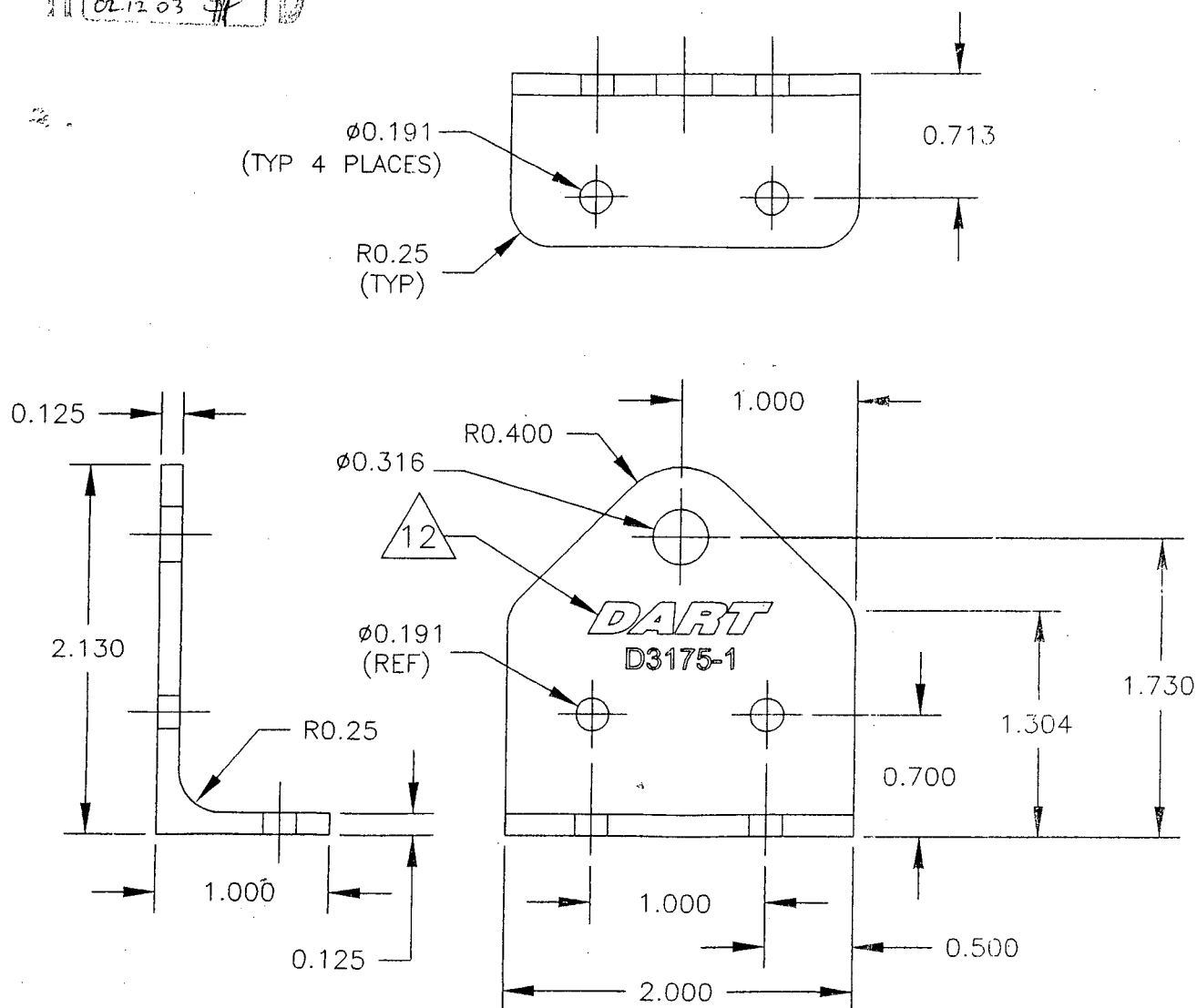
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

CONTROLLED COPY



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1

RELEASED  
02.12.03



### D3175-1 BRACKET

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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